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DART AEROSPACE LTD	Work Order:	19119
Description: Bracket ass'y	Part Number:	D2804-043
Dwg: D2804 rev.A1	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	KJ	03.05.07	8
2	STORES	Pick: Qty Part Number Description 1 D2804-1 Bracket B13773 1 D2805-3 Stop 1 D2809 Bushing	SB	03.04.07	8
3	METAL	Press D2805-3 into arm as per Dwg D2804	SB	03.04.08	8
4	QC	Inspect Level 5	SB	03.05.12	8
5	FINISHING	Powder coat white (4.3.5.1) per QSI 005	SB	03.05.14	8
6	QC	Inspect Level 3	SB	03.05.14	8
3	METAL	Press D2809 into arm as per Dwg D2804	SB	03.05.14	8
7	STORES	Pick: Qty Part Number Description Batch 1 AN3-16A Bolt M10454 2 AN960JD10 Washer M13263 1 MS21042L3 Nut M12241	SB	03.05.15	8
8	METAL	Assemble as per DWG D2804	SB	03.05.15	8
9	QC	Inspect Level 5	SB	03.05.20	8
10	STORES	Identify and stock	SB	03.05.20	8
11	EXPEDITING	Close W/O Cost / part: 74.37 500 03/05/21 (8)	SB	03.05.21	-

Rev	Date	Change	Revised By	Approved
A	01.04.06	New Issue	EC	
B	01.04.26	Re format	EC	EC

RELEASED

EC 01.04.26

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

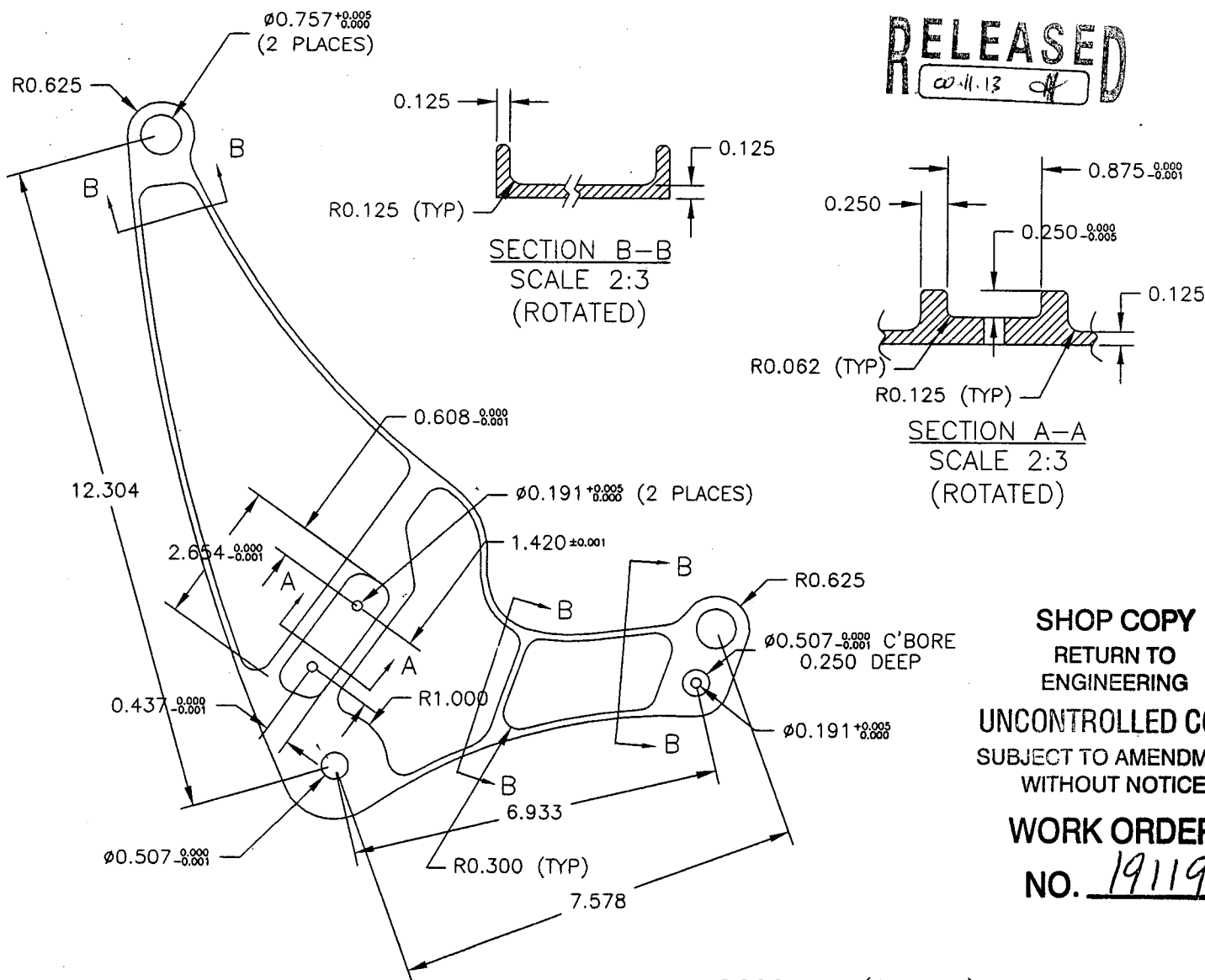
PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 # CP	



D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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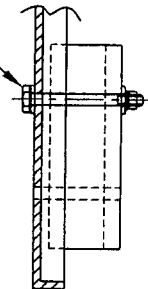
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3

RELEASED
00.11.13 #

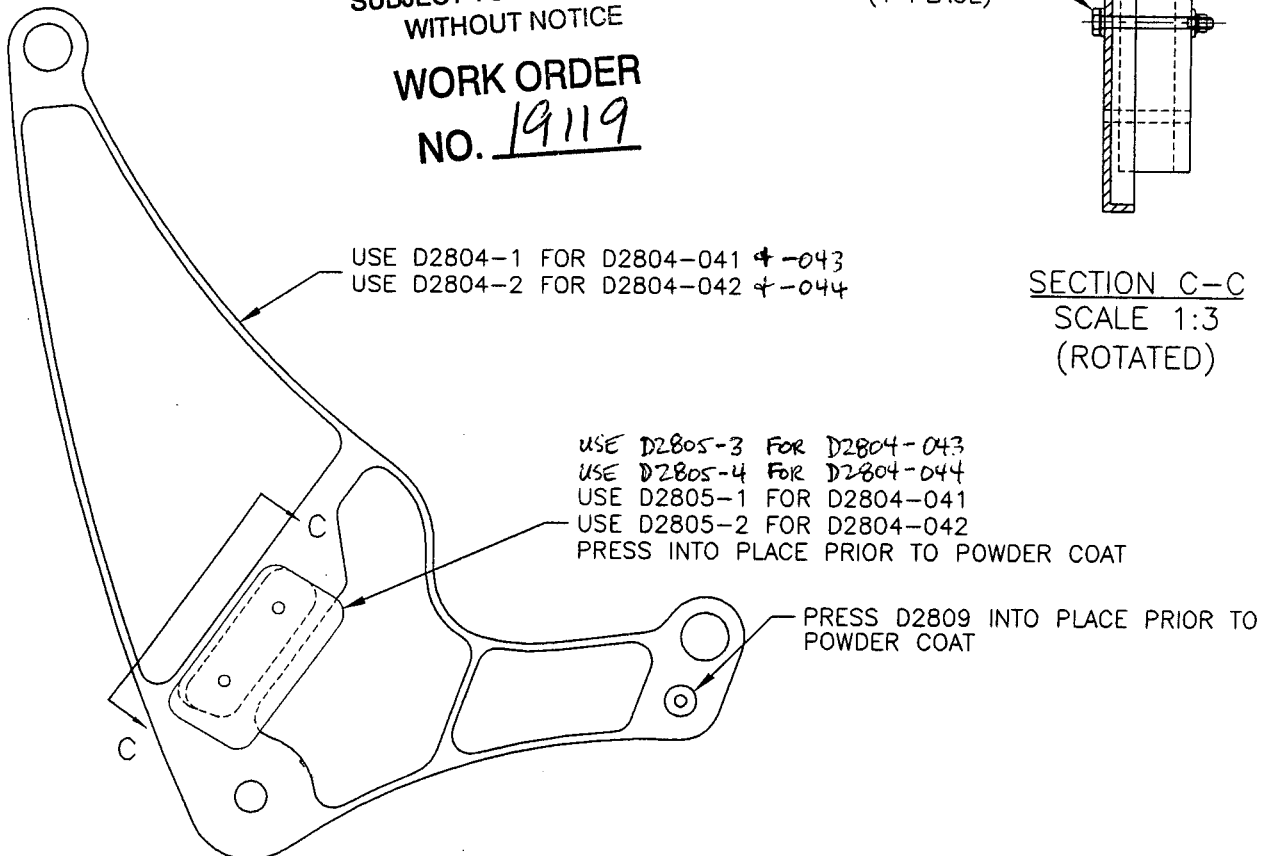
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 19119

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 07, 2003
11:47 am

Work Order No	:	0019119	Department Code:	
Project Name	:	D2804-043	Burden Flags	: NNNNNNNN
Project For	:	WK320	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2804-043	Invoice Number	:
Description	:	STA 155 Bracket Ass'y LH	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	8	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	05-07-03		
Est Finish Date	:	05-14-03	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:			

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Testing Hours	: 0.00	0.00	0.00		
Testing Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
SubContract Hours	: 0.00	0.00	0.00		
SubContract	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00